

Work Order ID 68284

Monday, April 11, 2011 12:49:56 PM

Page 1

Item ID: D2600-1-160

Accept

Setup Start

Revision ID:

Stop

Item Name: Extrusion Round 3" 206

Start Date: 4/11/2011 Start Qty: 60.00

Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 60.00

Customer:

Reference:

Approvals: Process Plan: 11/04/11 Date: 11/04/11 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2600 | Rev D1 |

100 0.00



Purchasing

PURCHASING

Memo

Purchasing

Issue P/O: 13848 ☐ a) Extrude as per Dwg D2600 ☐ b) Material: 6061-T6 (QQ-A-200/8) ☐ c) Minimum yield tensile strength = 35 ksi ☐ d) Minimum ultimate tensile strength = 40 ksi ☐ e) Minimum elongation = 8% ☐ f) Order at 160" long ☐ g) Bon L Canada Inc. tool #

02 11104112 83

110 0.00



Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Packaging

Ensure material certification is attached

11/04/11 (89)

120 0.00



QC

QC6- Inspect dimensions to drawing

Memo

Quality Control

Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester

11/05/11

1000

1000

1000

1000



11/05/11

Random checks.

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2600-1-160 PAR #: _____ Fault Category: Supplier NCR: Yes No DQA: _____ Date: _____
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

| NCR: <u>68284</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------------|--|----------------------------------|--|---------------------------------|---------------------------|----------------------------------|---------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>11/6/01</u> | <u>100</u> | <u>Qty xl length found with</u> <u>A "wave / twist" in center of tube.</u> <u>RL was the supplier</u> | <u>11.05.01</u> <u>CS104Z</u> | <u>→ Scrap + Destroy qty +1.</u> <u>inform supplier of issue and</u> <u>get credit for one PL.</u> | <u>11-5-1</u> <u>8/12/01</u> | | <u>11.05.01</u> <u>CS104Z</u> | <u>8</u> <u>ulabex</u> |
| | | <u>example of what is problem</u>  | |  | | | | <u>8</u> <u>ulabex</u> |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 68284

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Monday, April 11, 2011 12:49:56 PM

Item ID: D2600-1-160

Accept



Setup Start



Revision ID:

Stop



Item Name: Extrusion Round 3" 206

Start Date: 4/11/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: LC

0.00



Packaging

Memo

0.00

Packaging

CL 4/10/11 88

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/11/11 [Signature]CL 4/11/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 12:50:03 PM

Page 1

Work Order ID: 68284



Parent Item: D2600-1-160



Parent Item Name: Extrusion Round 3" 206


Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP D: ☐ 02.09.05 ☐ Added DSK 066 KJ/RF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|------------------|---------------|----------------------|--------|
| D2600-1-160P  Extrusion Round 3" 206 | | Purchased | No | | | 110 | Each | 0.0000 | 1 | 60 83 | | <i>Pur 4/17</i> (89) | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 1 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |
| A | 97.01.21 | NEW ISSUE | |
| B | 97.09.09 | CHANGE MATERIAL SPEC. | |
| C | 98.04.16 | ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO. | |
| D | 98.08.20 | INCREASE MIN. UTS TO 40 KSI | |
| DI | 01.04.17 | ADD PART NUMBERS & DIE NUMBERS <i>+GP</i> | |

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

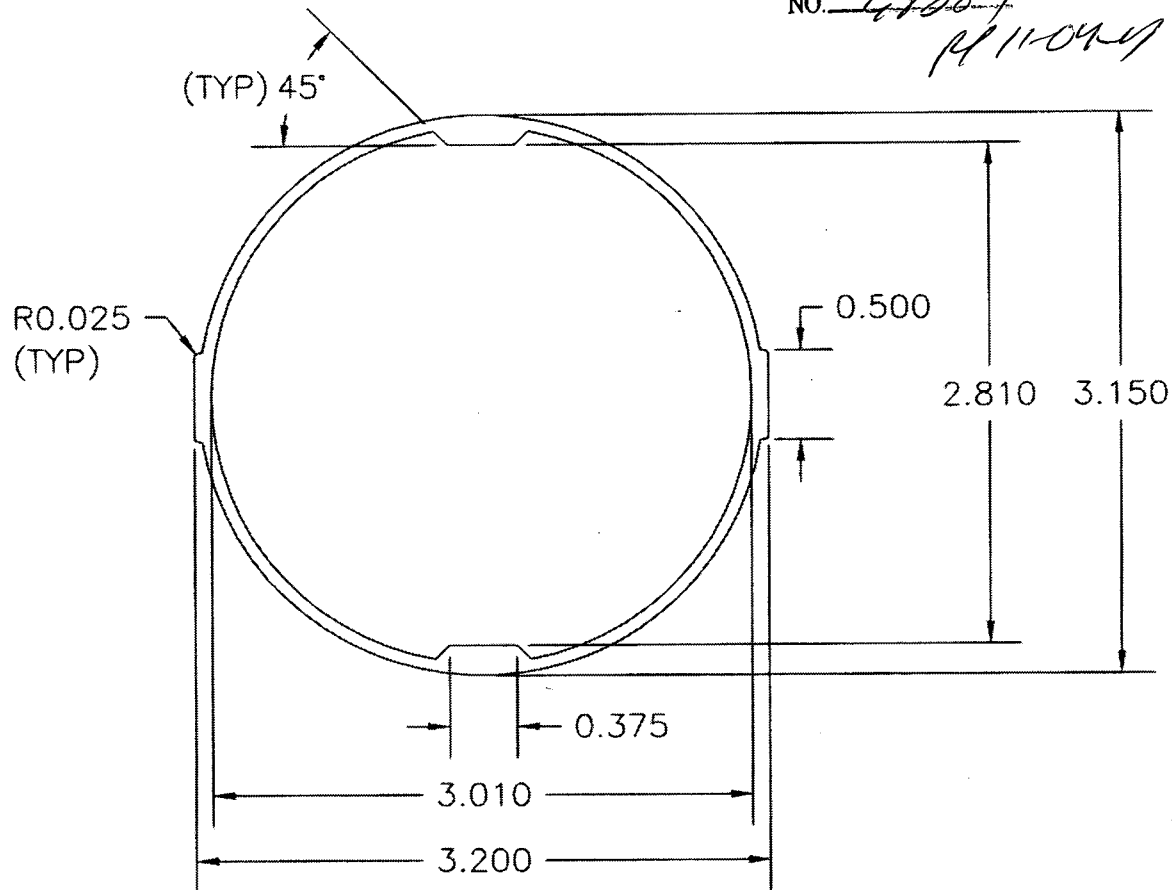
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 44264
4/11/04

DART



| | | | | |
|---------|-----------|----------|-----------|---|
| DESIGN | <i>DB</i> | DRAWN BY | <i>DB</i> | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | <i>VE</i> | APPROVED | <i>DB</i> | DRAWING NO. D2600 |
| DATE | 98.08.20 | TITLE | EXTRUSION | REV. D SHEET 2 OF 5 |
| | | | | SCALE 1:1 |



RELEASED
 98.8.25 DS

D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
 OR BON L DIE # 897121 (PREFERRED CHOICE)



PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

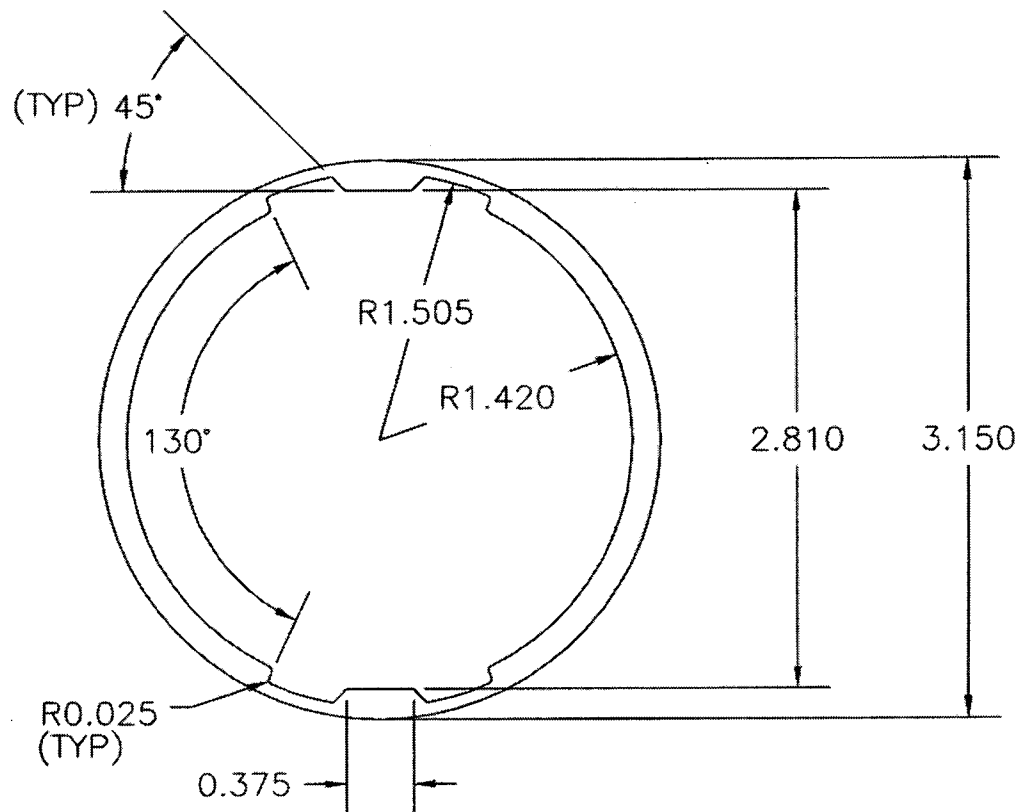
NOTE: Date & initial all entries

DART



| | | |
|----------|----------|---|
| DESIGN | DRN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| DATE | | D2600 |
| 98.08.20 | | TITLE |
| | | EXTRUSION |
| | | REV. D |
| | | SHEET 3 OF 5 |
| | | SCALE |
| | | 1:1 |

RELEASED
98.8.25 DS



D2600-3



MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)

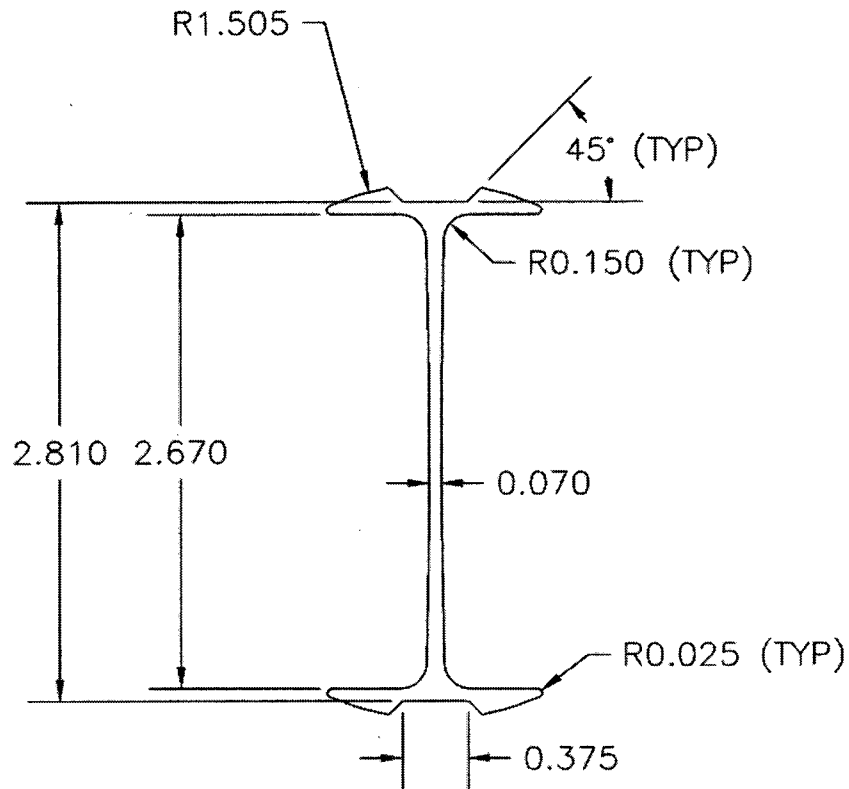
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

DART



| | | |
|----------------------|--------------------------------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 |
| DATE 98.08.20 | TITLE EXTRUSION | REV. 0 SHEET 4 OF 5 |
| | | SCALE 1:1 |

RELEASED
98.8.25. BS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

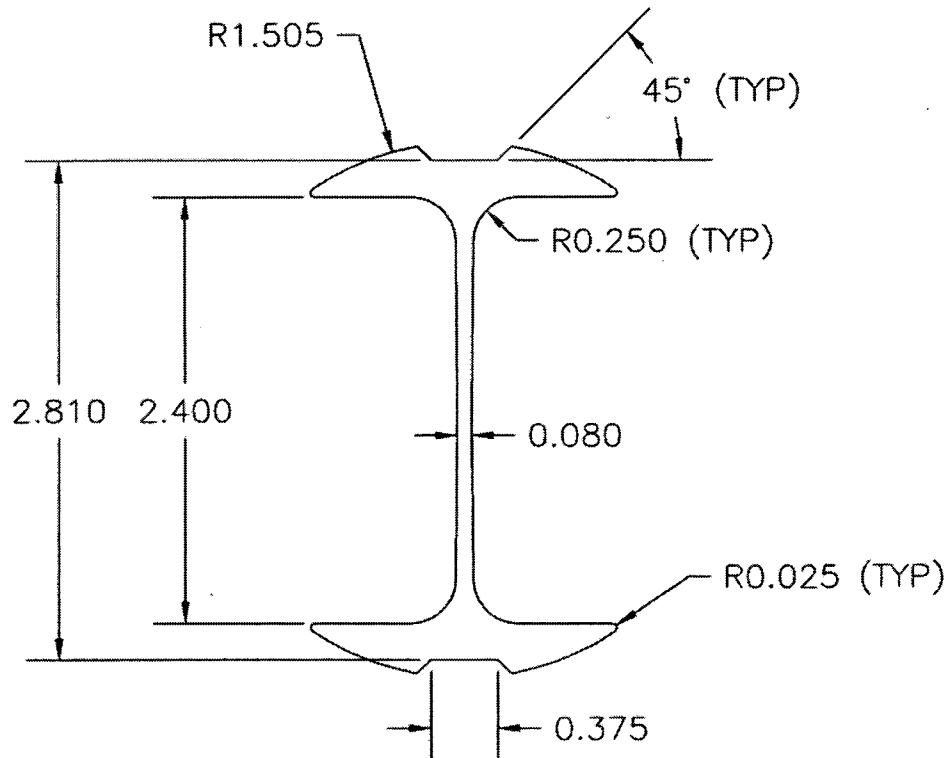


DART



| | | |
|----------------------|-----------------------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>JE</i> | APPROVED <i>JS</i> | DRAWING NO. D2600 |
| DATE 98.08.20 | TITLE EXTRUSION | REV. 0 SHEET 5 OF 5 |
| | SCALE 1:1 | |

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872

PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES

(EG. D2600-7-125 IS 125" LONG)





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13848

Purchase Order Date 4/12/2011

PO Print Date 4/12/2011

Page Number 1 of 2

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|---|----------------------|-----------------------------|-------------|------------|-------------------|
| 1 | D2423P | Lug Extrusion | 5/13/2011 Yes | 288.00 f | Yours ppd | \$10.9850 | \$3,163.68 |
| | | Special Inst: EXTRUDE AS PER DWG D2423 REV.B1 B68331 MATERIAL: 6061-T6 AS PER QQ-A-200/8 ALL DIMENSION ARE IN INCHES SIGNATURE ALUMINUM TOOL # DIE DAA-5 | | | | | |
| 2 | D2600-1-160P | Extrusion Round 3" 206 | 5/13/2011 Yes | 83.00 Each | Yours ppd | \$39.4030 | \$3,270.45 |
| | | Special Inst: EXTRUDE AS PER DWG D2600 REV. D1 B68284 MATERIAL: 6061-T6 AS PER QQ-A-200/8 MINIMUM YIELD STRENGTH = 35 KSI MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI MINIMUM ELONGATION = 8 % 160" LONG SIGNATURE ALUMINUM TOOL # 897121 | | | | | |

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 4/12/2011



ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE / DATE DU BODEREAU
05-16-11MANIFEST NUMBER / N° DE BODEREAU
001070SALES ORDER NUMBER / N° DE COM
100762

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

| LOCATION | TRAILER NUMBER / REMORQUE Nombre | SALESMAN / VENDEUR | CREDIT REP / REP DU CRÉDIT | SALES REP / REP. DES VENTES |
|----------------------------------|-------------------------------------|--|----------------------------|--|
| PIC | GOLDEN | 138 | | H. CAMERON |
| JOB / FICHIER | | FIELD SALES REP / REP REGIONAL DES VENTES | | CUST SERVICE REP / REP. SERVICE CLIENTELE |
| CARRIER / TRANSPORTEUR GOLDEN | | M. BATES | | cgerard |

CUSTOMER ID / ID DU
CLIENT

46024

ORDER DATE / DE LA
COM

04/12/11

CUSTOMER PO NUMBER / CLIENT PO Nombre

13848

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

001070

| ITEM NO. / NUMÉRO | ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL | UNIT / UNITÉ | PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée | MFG. PART NUMBER / MFG. PARTIE NUMÉRO | ALLOY & TEMPER / ALLIAGE & TEMPER | FINISH DESCRIPTION / DESCRIPTION DE FINITION | NBR OF PKGS / NBR DE PKGS | GROSS LBS / LIVRES BRUT | NET QUANTITY / QUANTITÉ NETTE | UNIT / UNITÉ | QUANTITY DUE / Quantité en raison |
|-------------------------|---|-----------------|--|--|--------------------------------------|--|------------------------------------|----------------------------|-------------------------------------|-----------------|--|
| 002 | 1,108 | LB | | DAA-897121-1 | 6061 | | 2 | 1,157 | 1,113 | LB | |
| | 502 | KG | | D2600-1-160 | 160.0000 IN | | | 525 | 505 | KG | |
| | 83 | PC | | | Cut(+): 0.0000 Cut(-): 0.0000 | Min: 0 % Max: 0 % | | | 89 | PC | |

802083 / 106223

1

556

534

43 PC

802083 / 106224

1

602

580

46 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

| | | | |
|--------|-------|-------|----|
| 2 | 1,157 | 1,113 | LB |
| | 525 | 505 | KG |
| | | 89 | PC |
| TOTALS | | | |

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

| Cert Date | Cert No | Sales Order | Page |
|------------|---------|-------------|----------|
| 05/06/2011 | 5260546 | 100762 | 1 |
| Cust PO | B/L No | Lot | Date |
| 13848 | 001070 | 802083 | 05/16/11 |

| Sold To | Ship To |
|---|---|
| 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA | 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA |

| Item No | Part No | Item Description | Cust Part |
|---------------|-------------------------------|-------------------|-------------|
| 002 | DAA-897121-1 | 160" Mill 6061 T6 | D2600-1-160 |
| Gross Weight | 1,157 LBS | | |
| Net Qty | 1,113 LBS | 89 PCS | 2 PKGS |
| Specification | AMS-QQ-A-200/8 & ASTM B221-08 | | |

Mechanical Tests:

| | | | | |
|--------------|--------------|--------------|--------------|------|
| Tensile | Yield | % Elongation | Conductivity | HREW |
| MPA / KSI | MPA / KSI | | | |
| 306.2 / 44.4 | 278.7 / 40.4 | 10.1 | 0.0 | 95 |

8/11/05/17

Chemical Analysis:

| | | | | | | | |
|------|------|------|------|------|------|------|------|
| SI | FE | CU | MN | MG | CR | ZN | TI |
| 0.66 | 0.30 | 0.25 | 0.08 | 0.90 | 0.06 | 0.07 | 0.02 |

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

R. Petersen, QA Manager Signature Aluminum Canada Inc

